

Work Order ID 101177

101177

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May-02-13 11:51:14 AM

Item ID: D205-634-111

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube

Start Date: 5/02/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 1.00 *1*

Customer:

Reference: rework - ECN13-544

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D205-634	G

100

0.00

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D205-634-111
CHG 004

0.00

101

0.00

101

HandFinish

Hand Finishing

Memo

1 X D205-634-111 B82857
REMOVE THE 2 WEARPLATES
1 X D4406-041 / 1 X D4406-043
SCRAP
INSTALL NEW WEARPLATES AT REV.C
1 X D4406-041 B _____
1 X D4406-043 B _____

0.00

Work Order ID 101177***101177***

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May-02-13 11:51:14 AM

Item ID: D205-634-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube

Start Date: 5/02/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN13-544

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP USING NEW B/N
NEW LABELS AND PAPERWORK REQ'D
@ CHG004
Identify and pack for shipping as per PPP D205-634-111
Location: _____
PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

w 1346-11

Picklist Print

Page 1

May-02-13 11:51:13 AM

Work Order ID: 101177

Parent Item: D205-634-111

Parent Item Name: Skidtube

Start Date: 5/02/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.09.26 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER
ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-634-111		Manufactured	No				Each	0.0000		1	82857		
Skidtube													
D4406-041		Manufactured	No				Each	6.0000		1			
Fwd Wearplate Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FP002		6							
				98746		6							
D4406-043		Manufactured	No				Each	6.0000		1			
Aft Wearplate Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FP001		6							
				98747		6							

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 13.03.21	Job No.: ENG4108	ADR Yes/No: Y	ADR Date: 13.03.21	ECN #: 13- 544
Product No.: D205-634		Created By: AJS	Approved By: <i>[Signature]</i>	
Product Name: SKID TUBE (TRAINING WEARPLATE)		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.		DL	
Customer Order Processing		RM/CA	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/DS	
Marketing		HM	

Reason for Change: DESIGN IMPROVEMENT

Documents Affected:
D4406 & D4407 REV. C
MDL-D205-634 REV. Y

PAPERWORK UPDATE ☐ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	AJS		13.03.21 DS
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		13.03.21 <i>[Signature]</i>
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		13.03.21 <i>[Signature]</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW	13.03.21 <i>[Signature]</i>
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		13.03.21 <i>[Signature]</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		13.03.21 <i>[Signature]</i>
24	Manufacturing Licensing Agreement Update	N			

Description / Action:

ROLL D205-634-111 TO CHG 004 101175 - 101176 - 101177 - 101178

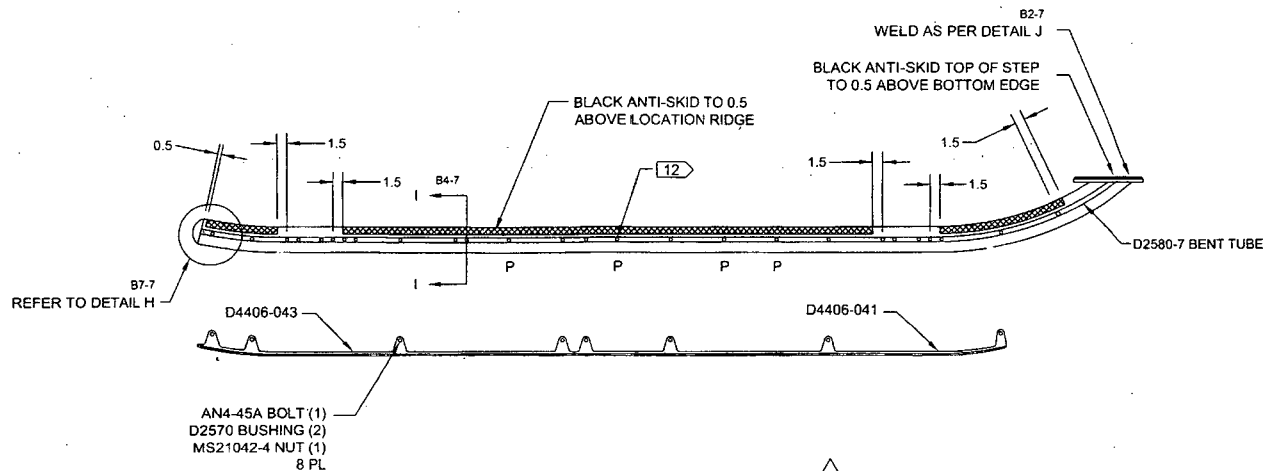
ROLL D205-634-141 TO CHG 004

ROLL D205-634-143 TO CHG 003

Scrap any D4406 or D4407 parts in stock manufactured before Rev. C 95737-738.739

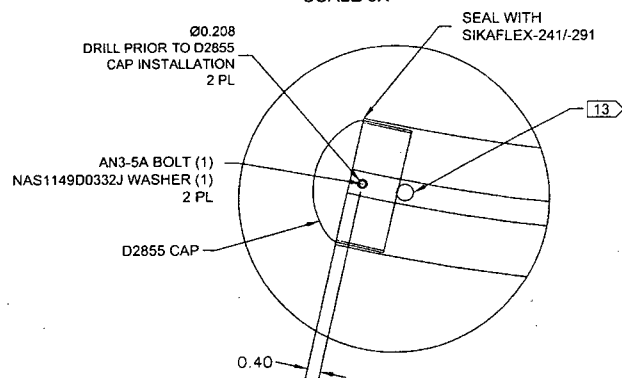
Release D4406 & D4407

ECN Verified & Complete: _____ Date: _____

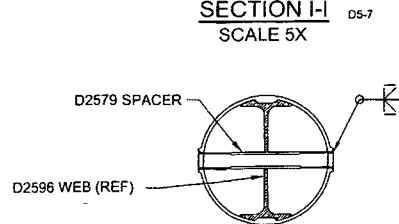


D2580-047 ASSEMBLY DETAIL E

DETAIL H
SCALE 5X

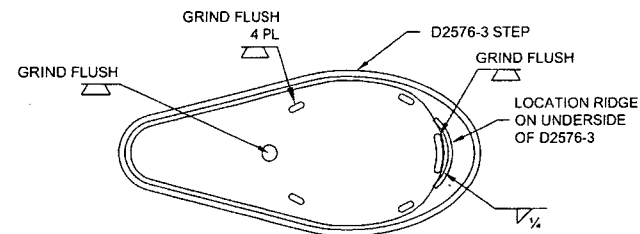


SECTION I-I
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (25 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J
SCALE 5X



DEO ATTACHED
RELEASED
2011-08-28

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. E
CHECKED	AP	D2580	SHEET 6 OF 8
MFG. APPR.	AP	TITLE	SCALE
APPROVED	AP	205 SKIDTUBE ASSEMBLY	NTS
DE APPR.	AP		
DATE	11.06.21	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

w/b 10/11/77